

Date: Thursday, 12/13/2007 2:38:58 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number : 36325	
Estimate Number : 10534	
P.O. Number : <u>N/A</u>	Part Number : D2574
This Issue : 12/13/2007 S.O. No. : <u>NA</u>	Drawing Number : D2574 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 35934	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 1/10/2008 Qty: 16 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev As Per RevE 06-01-27 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101005	7075-T7351 8.25X5.0X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)
7075-T7351 8.25X5.0X2.5
Make from D6101-005 billet for D2574
Ensure that grain is along 5.00" length
Batch No: B 31384

SF 08/01/08

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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PFO

Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No. 36325 Double check by: J.L

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
4-Deburr and remove all machining marks
5-Tumble to remove sharp edges.

SF 08/01/08

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
Machine keyway as per dwg D2573 & D2574

SF 08/01/08

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SF 08/01/08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/01/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/01/09	#20	During second operator machine started the 1" rougher the holder hit the part and caused a large chamber R.C. Hammer error	CP 08.01.09 per Q51042	Build out chamber & blends m. PART ACCEPTABLE. DOES NOT AFFECT STRENGTH OF PART	S.F. 08/01/09	08/01/09	CP 08.01.09 per Q51042	08/01/09

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 36325

Part Number: D2574

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 08/01/17

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

m.f.

08/01/15

(16X)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m.f.

08/01/16

(16X)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

AS

FEL

08/01/16

(16)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51433

AS

08/01/17

(X16)

(16)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 08/01/17

Job Completion



h 08/01/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 36325
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. E	Page 1 of 1

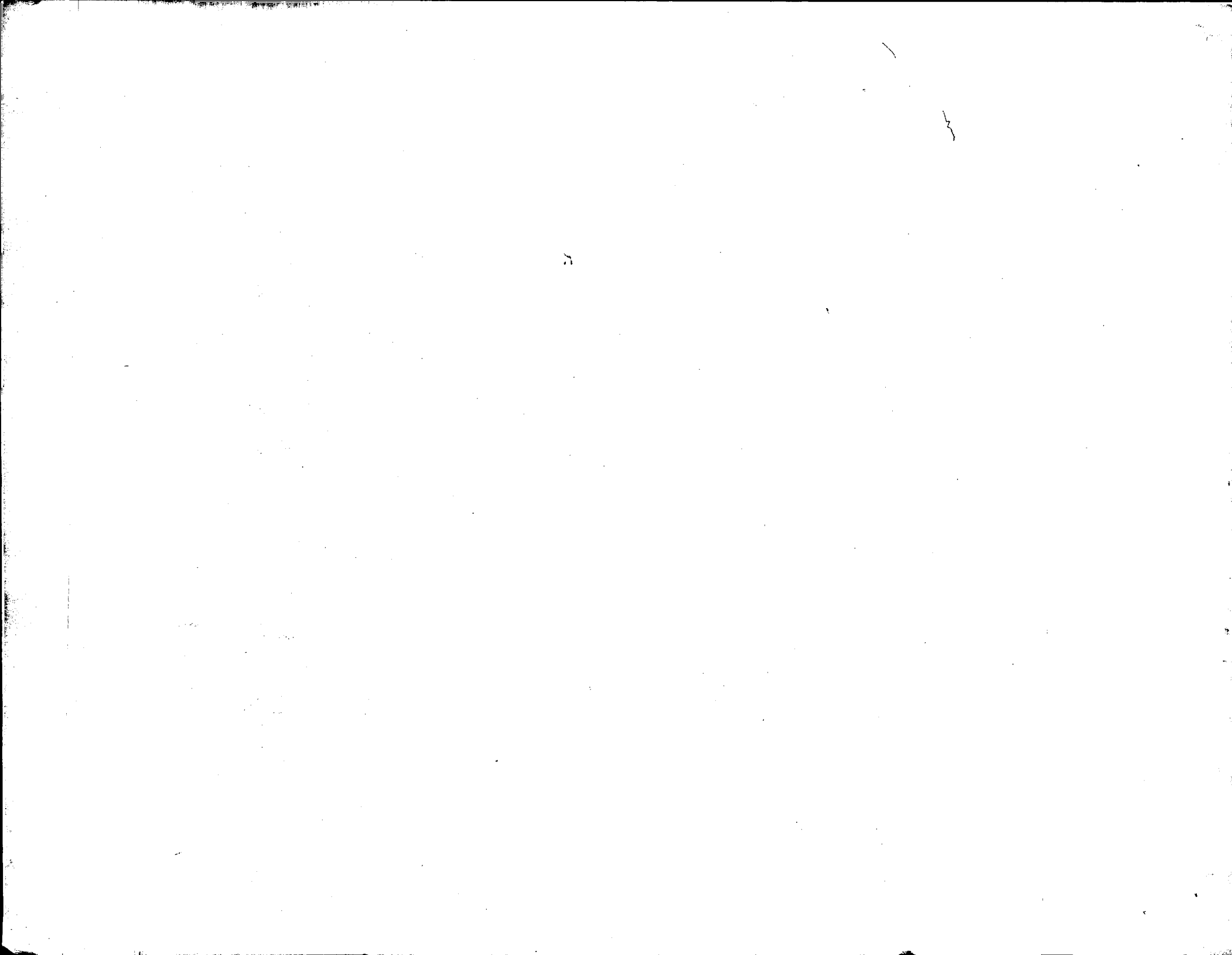
Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.441	.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.501	.501	.501	.501		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		.568	.568	.568	.568		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.365	1.375		1.375	1.375	1.375	1.375		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.240	.256	.256	.256		
S	0.115	0.135		.126	.126	.126	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.232	3.232	3.232	3.232		
V	0.230	0.250		.230	.238	.230	.230		
W	0.115	0.135		.125	.128	.128	.128		
X	0.307	0.312		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.358	.360	.360	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.625	.625	.635		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.520	1.517	1.510	1.510		
AF	0.115	0.135		.125	.130	.130	.130		
AG	0.240	0.280		.285	.275	.275	.275		
AH	0.240	0.260		.250	.251	.250	.252		
AI	2.000	2.020		2.000	2.002	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: RF
Date: 08/01/08

Audited by: SA
Date: 08/01/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



DART AEROSPACE LTD	Work Order:	36325
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5	6	7	8	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.003	8.003	8.003		
F	0.490	0.510		.505	.505	.505	.505		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.377	.377	.377	.376		
I	0.490	0.510		.503	.503	.503	.503		
J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		.567	.567	.569	.569		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.365	1.375		1.375	1.375	1.375	1.375		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.128	.128	.130	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.232	3.232	3.232	3.232		
V	0.230	0.250		.240	.240	.240	.240		
W	0.115	0.135		.134	.134	.134	.134		
X	0.307	0.312		.310	.310	.310	.310		
Y	0.760	0.765		.764	.764	.764	.764		
Z	0.352	0.372		.362	.362	.362	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.635	.635	.635	.6		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		.130	.130	.130	.130		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.002	2.002	2.005	2.005		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	RF 134
Date:	08/01/09

Audited by:	SA
Date:	08/01/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	36325
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

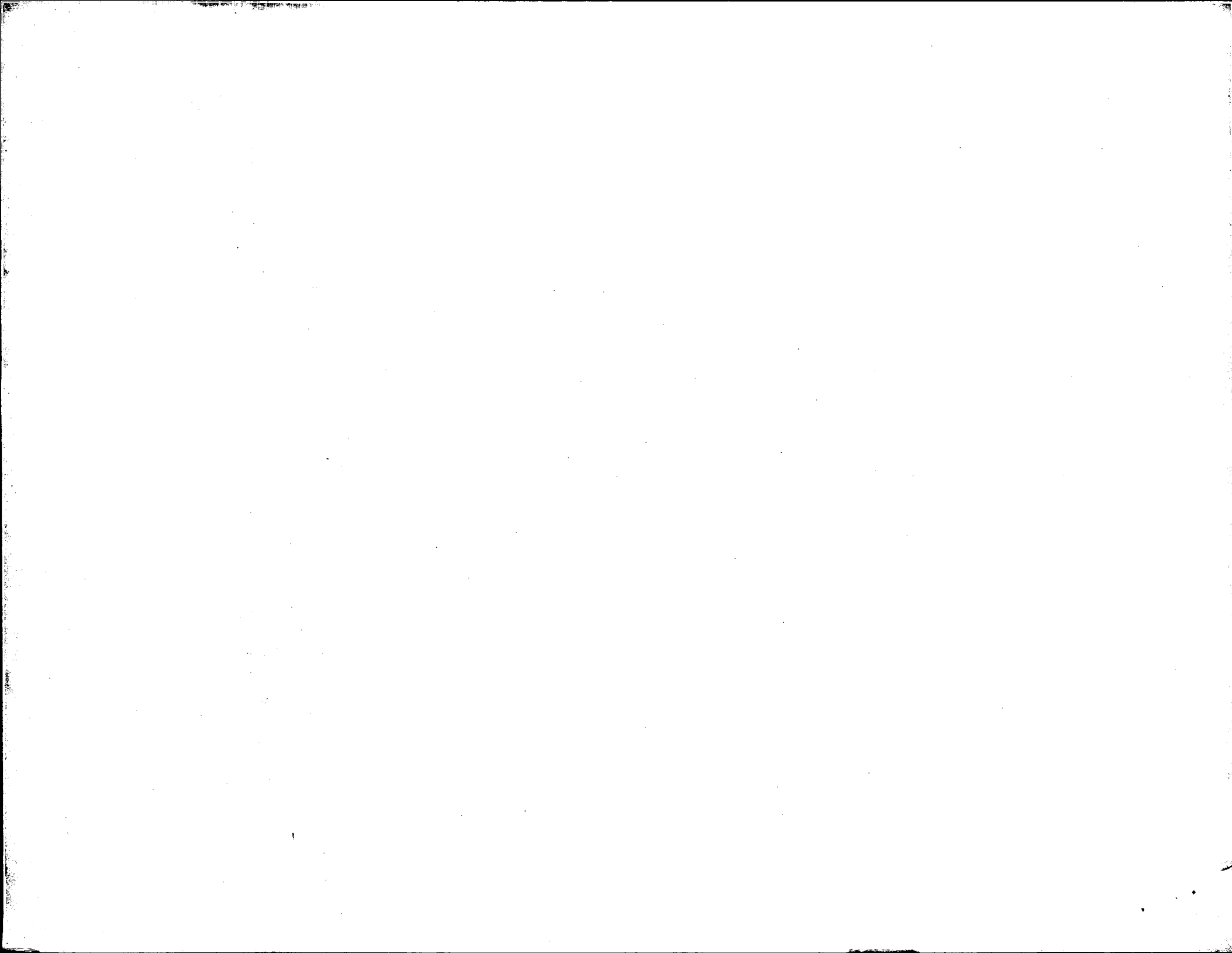
Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	9 1	10 2	11 3	12 4	By	Date
A	0.438	0.443		.440	.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.002	8.002	8.002		
F	0.490	0.510		.505	.500	.507	.502		
G	0.257	0.262		.260	.258	.258	.258		
H	0.375	0.380		.376	.377	.377	.377		
I	0.490	0.510		.502	.500	.500	.500		
J	1.174	1.184		1.179	1.180	1.180	1.180		
K	0.558	0.578		.569	.568	.568	.568		
L	1.174	1.184		1.179	1.180	1.180	1.180		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.121	4.124	4.124	4.124		
P	0.115	0.135		.125	.128	.130	.130		
Q	0.115	0.135		.130	.135	.135	.135		
R	0.240	0.260		.255	.255	.255	.255		
S	0.115	0.135		.130	.126	.128	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.233	3.233	3.233	3.233		
V	0.230	0.250		.240	.243	.243	.243		
W	0.115	0.135		.132	.135	.130	.130		
X	0.307	0.312		.310	.310	.310	.310		
Y	0.760	0.765		.764	.764	.760	.760		
Z	0.352	0.372		.362	.362	.360	.360		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.630	.630	.627	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.515	1.515	1.515	1.515		
AF	0.115	0.135		.135	.135	.130	.126		
AG	0.240	0.280		.265	.265	.265	.265		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.005	2.002	2.000	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	RF/RF
Date:	08/01/12

Audited by:	SA
Date:	08/01/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



DART AEROSPACE LTD	Work Order: 36325
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

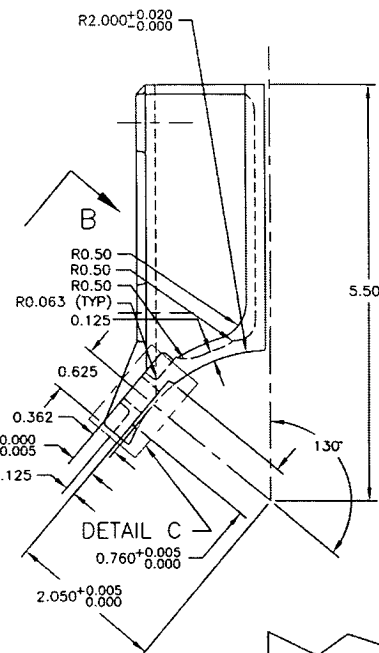
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	13 1	14 2	15 3	16 4	By	Date
A	0.438	0.443		.441	.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		.500	.500	.501	.501		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.377	.377	.376	.376		
I	0.490	0.510		.503	.502	.502	.502		
J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		.570	.570	.570	.570		
L	1.174	1.184		1.180	1.180	1.180	1.180		
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N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.123	4.124		
P	0.115	0.135		.126	.126	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.258	.258	.256	.257		
S	0.115	0.135		.126	.128	.128	.129		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.233	3.233	3.233	3.233		
V	0.230	0.250		.242	.240	.240	.240		
W	0.115	0.135		.125	.128	.128	.128		
X	0.307	0.312		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.360	.360	.360	.360		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.627	.628	.629		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.250	.250	.251	.251		
AI	2.000	2.020		2.001	2.001	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: RF
Date: 08/01/12





Audited by: SA
Date: 08/01/14

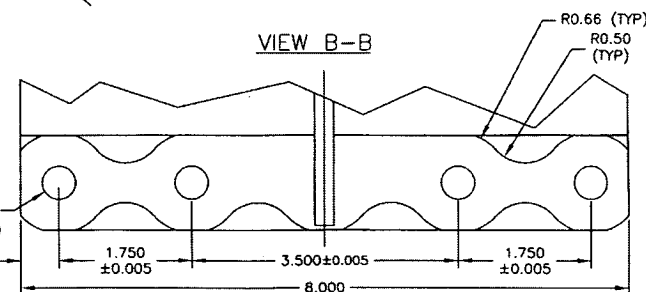
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B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

05.12.06



MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- | | |
|---|--|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
|  | CHAMFER 0.063 x 45° ALL AROUND |
|  | CHAMFER 0.033 x 45° (SEE DETAIL C) |



DETAIL C
SCALE 2:1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 3632

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AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

DESIGN	DRAWN BY		DART AEROSPACE LTD. HAMMERSLEY, ONTARIO, CANADA
DS	PH		
CHECKED	APPROVED	DRAWING NO.	REV.
		D2574	
DATE		TITLE	SCALE
05.07.13		INNER AFT SADDLE	2: